

Work Order ID 50002

July 2, 2009 2:57:05 PM



Page 1

Item ID: D2873-043
Revision ID: A
Item Name: Nut Plate Assembly

Accept



Setup Start



Stop



Start Date: 7/03/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/08/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2873	Rev A

100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	<i>DJP</i> <i>09/07/05</i> <i>(20)</i>	Memo							
		Cut blanks: 1.000" x 0.375" x 3.700" long							

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	<i>DJP</i> <i>09/07/06</i> <i>(20)</i>	Memo							
		Machine as per Folio FA and Dwg D28731 Identify as D2873-3							
		Dwg Rev <i>A</i> Folio Rev <i>AA</i>							

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	<i>DJP</i> <i>09/07/06</i> <i>(20)</i>	Memo							

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QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	=> Sorlozlo 9		counts (+20)		6		
140 Small Fab Small Fab	Small Fab Memo 1-Deburr 12- C'sink as per Dwg D2873	0.00 0.00	ep 09/07/13		(20)				
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> Sorlozlo 13		counts (+20)		6		

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Required Date: 7/08/09 Req'd Qty: 20.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

09-07-13

20

BA

Memo

0.00

170

QC
Quality Control

QC3- Inspect Part Finish

0.00

09-07-13

20 self

Memo

0.00

180

Small Fab
Small Fab
Small Fab

Small Fab

0.00

0.00

Memo

1-Assemble as per Dwg D2873 12-Identify as D2873-043

EP 09/07/20

20

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Required Date: 7/08/09 Req'd Qty: 20.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190
QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> 801/260

count
420

f

Memo

0.00

200
Packaging
Packaging

Identify as per dwg & Stock Location: ~~X-tube~~ Finishing

0.00

=> ml 09.07.20

Memo

0.00

210
QC
Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/07/2009

MF 09-07-20

Memo

0.00

Picklist Print

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Work Order ID: 50002

Parent Item: D2873-043RevA

Parent Item Name: Nut Plate Assembly

Comments:

Start Date: 7/03/09

Required Date: 7/08/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5		Purchased	No			100	Each	110.0000	60.0000			



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

110

110916

79

111127

31

M6061T6B0.375X01.00

Purchased

No

180

f

40.1000

6.4905

0



6061T6 BAR .375 x 1.00



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

40.1

105225

5.3

110829

34.8

DTP 09/07/06

O no stack.
M 31 09/07/13 EP.
M11224329

6.4905

Picklist Print

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Work Order ID: 50002

Parent Item: D2873-043RevA

Parent Item Name: Nut Plate Assembly


Comments:

Start Date: 7/03/09

Required Date: 7/08/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6		Purchased	No			180	Each	4,548.000	120.0000			
												
Rivet												



09/07/13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4548

100151

27

103395

14

105144

706

110139

3774

2525

27

120

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Shop Packet Print

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DART AEROSPACE LTD		Work Order:	50002
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

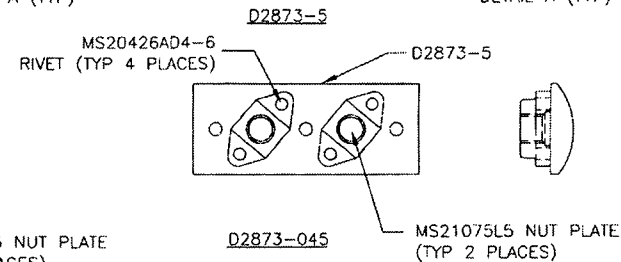
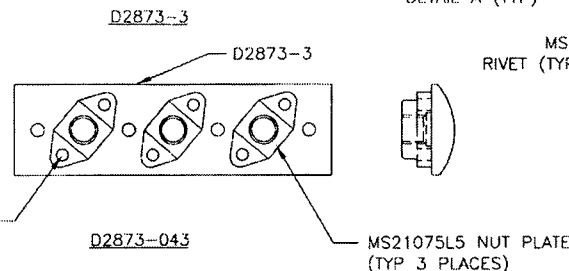
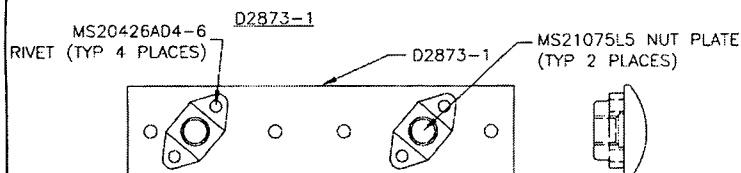
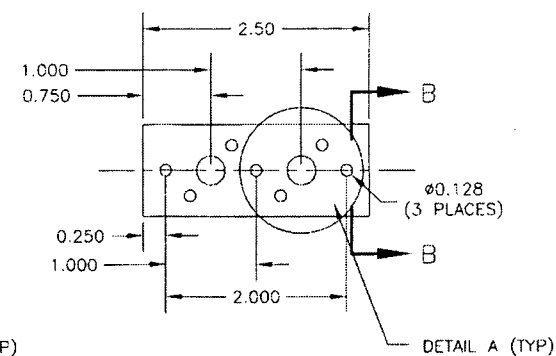
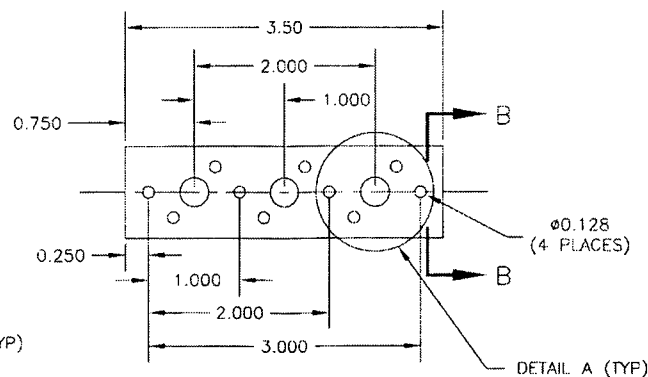
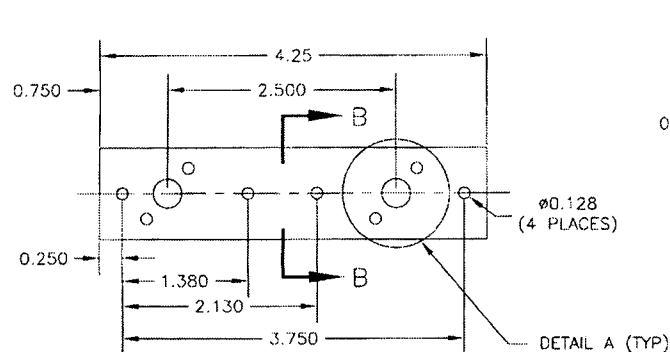
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓			
2.000	+/-0.010	1.999	✓			
0.750	+/-0.010	0.749	✓			
1.000	+/-0.010	0.999	✓			
0.250	+/-0.010	0.248	✓			
1.000	+/-0.010	1.002	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	0.130	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	0.317	✓			
1.000	+/-0.010	0.996	✓			
0.250	+/-0.010	0.248	✓			
0.061	+/-0.010	0.065	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.128	✓			

Measured by: DJP	Audited by: S	Prototype Approval:	N/A
Date: 09/07/06	Date: 09/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	



D2873-041

MS20426AD4-6 RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE (TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE (TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

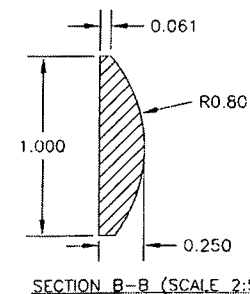
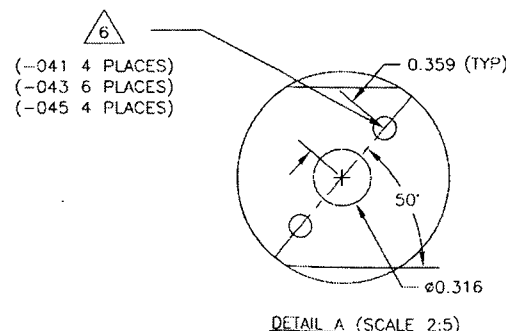
- MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE INCHES
- BREAK ALL SHARP EDGES 0.010 TO 0.020
- Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 X 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DART AEROSPACE LTD
DATE 05.07.26	DRAWING NO. D2873	REV A SHEET 1 OF 1
	TITLE RADIUS BLOCK	SCALE 4:3

C209/07/02
W10, 50002